

Work Order ID 119700

May-16-14 9:06:01 AM

\*119700\*

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D2271-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: ~~PRELIM~~ Release Stop \*NS2\*  
 Item Name: "L" Bracket Assembly  
 Start Date: 5/16/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 5/20/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: ✓ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2271	<del>PB1</del> Rev B 5/14/27

100 Weld per dwg A/R S.S. rod Batch: M125654 0.00  
 Small Fab

\*100\*

Large Fab

Large Fab

Memo

WELD RADIUS BLOCK TO L-BRACKET AND GRIND FLUSH AS PER DWG.

2 EA 14-6-5

105 QC10- Inspect visual per QSI004- ground welds 0.00

\*105\*

QC

Quality Control

Memo

DAS

27

9-19

0.00

14/6/6

2  
 Inspect as per  
 Draw PB1

110 QC5- Inspect part completeness to step on W/O 0.00

\*110\*

QC

Quality Control

Memo

DAS

27

9-19

0.00

14/6/6

2  
 Inspect as per  
 Draw PB1

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Page 2

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location:	0.00							
*120*									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
*130*									
QC	Memo	0.00							
Quality Control									

SHIPPED TO DAVID S. *[Signature]*

14/9/9 *[Signature]*

*[Signature]* 14-6-6.

POSITIVE RECALL  
 EFFECTIVE 4/25/70 AUTH *[Signature]*  
 RELEASED 11/28/77 DATE *[Signature]*

to Rev B Day oh.

May-16-14 9:06:01 AM

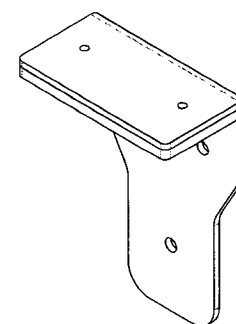
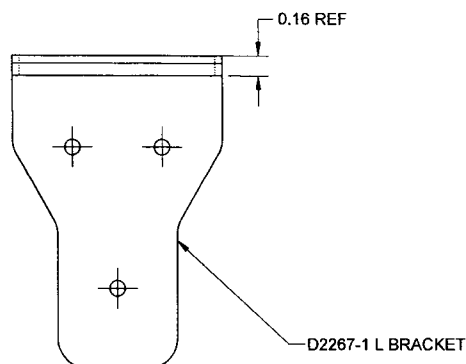
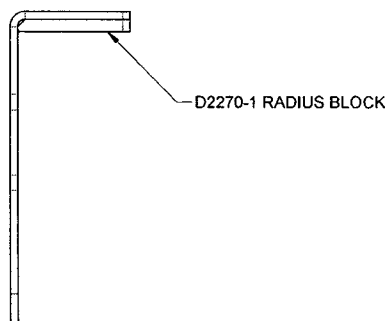
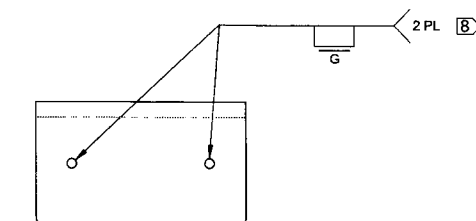
**\*1 19700\***

**\*D2271-041\***

**Required Qty: 2.00**

[illegible]

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2271-041	L BRACKET ASSY
1	1	D2267-1	L BRACKET
2	1	D2270-1	RADIUS BLOCK



# **D2271-041 L BRACKET ASSY**

W/O 119700

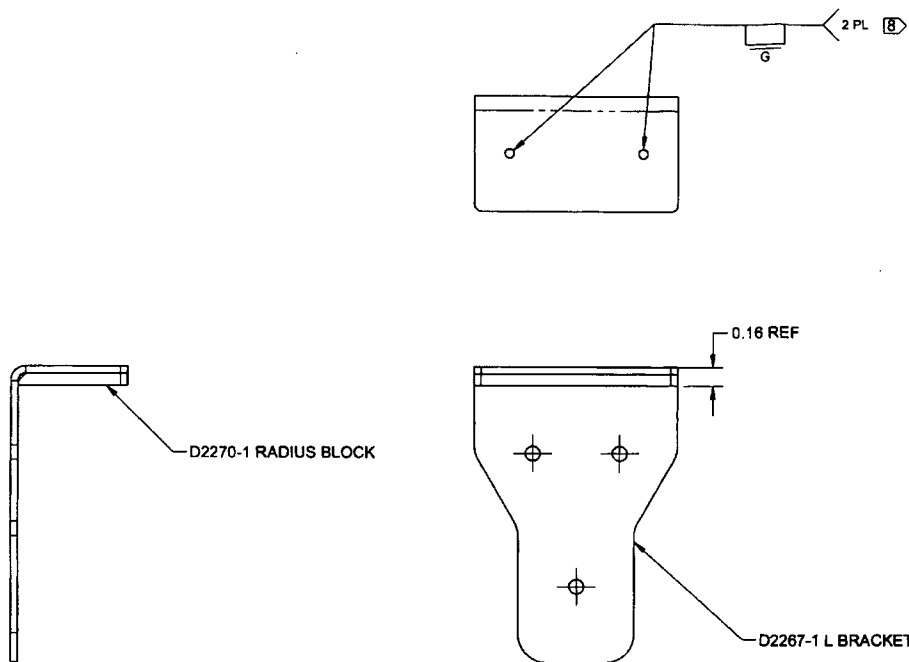
## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2271-041" PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) WELDING PER QSI 004

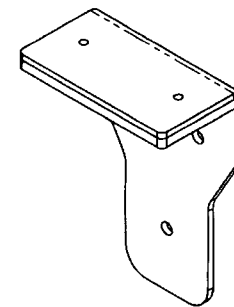
B	RE-FORMAT DRAWING, DELETE MS20426AD4-4 RIVETS	DB	14.03.27
A	NEW ISSUE	MC	94.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	JLM	<b>D2271</b>	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>L BRACKET ASSY</b>	NTS
DATE	14.03.27	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED

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1	1	D2267-1	L BRACKET
2	1	D2270-1	RADIUS BLOCK



**D2271-041 L BRACKET ASSY**



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  - 7) WEIGHT: 0.10 lbs
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**RELEASED**  
2014-08-27

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APPROVED

REV. B  
SHEET 1 OF 1  
SCALE  
NTS